

Work Order ID 61235

Wednesday, August 11, 2010 11:30:44 AM



Page 1

Item ID: D4149-1

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug Plate, Aft

Stop



Start Date: 8/12/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 8/26/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

MS

Date:

10-8-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4149	B								

100

0.00



Waterjet

Memo

0.00

IB 10-8-16

FLOW CNC Waterjet

Cut as per dwg D4149

Prog Rev: *B*

Dwg Rev: *B*

304 .125

Deburr as required

(11)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

IB 10-8-16

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/08/17

X11

150

Identify as per dwg & Stock Location: ST123

0.00



Packaging

Memo

0.00

Packaging

X11 BB
10/08/17

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/17
CME
10-8-17

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Picklist Print

Wednesday, August 11, 2010 11:30:43 AM

Page 1

Work Order ID: 61235



Parent Item: D4149-1



Parent Item Name: Crosstube Lug Plate, Aft



Start Date: 8/12/2010

Required Date: 8/26/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	82.3023	0.1355	1.426316	1.5		
													

B10-8-16

Location

Loc Qty

Loc Code

MAT

82.3023

114799

82.3023

114799

11

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DART AEROSPACE LTD		Work Order: 61235
Description: Aft Crosstube Lug Plate		Part Number: D4149-1
Inspection Dwg: D4149	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.131	x		✓ Ro2	
Ø0.191	+0.005/-0.001	.192	*		✓	
Ø0.257	+0.006/-0.001	.257	*		✓	
Ø0.38	+0.006/-0.001	.379	x		✓	
0.380	+/-0.010	.380	*		✓	
0.469	+/-0.010	.471	*		✓	
0.310	+/-0.010	.309	*		✓	
0.750	+/-0.010	.748	*		✓	
3.25	+/-0.030	3.246	*		✓	
0.65	+/-0.030	.644	*		✓	
0.63	+/-0.030	.627	*		✓	
5.46	+/-0.030	5.46	*		✓	
3.80	+/-0.030	3.80	*		✓	
2.13	+/-0.030	2.13	*		✓	
1.313	+/-0.010	1.312	x		✓	
0.625	+/-0.010	.624	*		✓	
0.375	+/-0.010	.373	*		✓	
1.175	+/-0.010	1.179	*		✓	
0.752	+/-0.010	.754	x		✓	
1.588	+/-0.010	1.586	x		✓	
1.587	+/-0.010	1.586	*		✓	
11.15	+/-0.030	11.150	x		✓	
0.750	+/-0.010	.760	x		J Ro1	
1.55	+/-0.030	1.555	*		✓	
1.12	+/-0.030	1.132	*		✓	
8.42	+/-0.030	8.420	x		✓	
2.70	+/-0.030	2.701	*		✓	
0.125	+/-0.010	.119	x		✓	

Measured by: RB	Audited by: S	Preliminary Approval:	N/A
Date: 10-8-16	Date: 10/05/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	

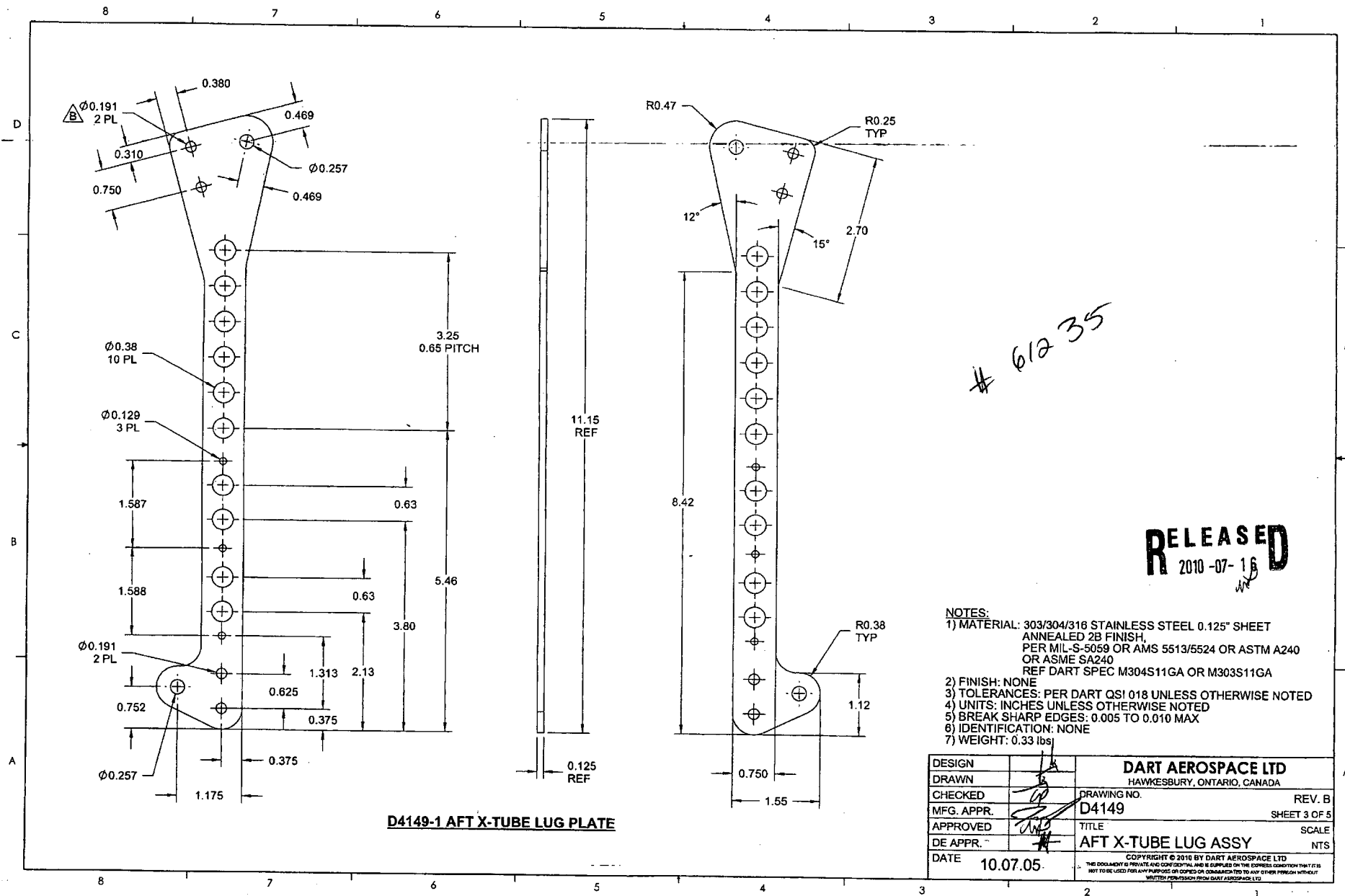
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